



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2348
Job Sheet 170304



Part No: D2348

Job Qty: 20 ea

Part Name: Wearplate (Key Way)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV C IPP Rev A Removed from 9 Digit 05-12-05 JLM IPP Rev:B Now on Waterjet 06-07-03 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		1/18/18	0.00	0.00	Start Up Waterjet		<i>a 18/01/13</i>
100	Waterjet	20 pcs		1/18/18	0.01	0.74	Waterjet1		<i>a 18/01/13</i>
120	QC	20 pcs		1/18/18	0.00	0.00	QC8		<i>38</i>
150	Outsource	20 pcs		1/18/18	0.00	0.00	Outsource4		<i>18/1/20</i>
160	Packaging	20 pcs		1/18/18	0.00	0.00	Packaging2		<i>18/1/20</i>
170	QC	20 pcs		1/18/18	0.00	0.00	QC5		<i>38</i>
180	Small Fab	20 pcs		1/19/18	0.00	0.55	Small Fab		<i>9-89 DAS</i>
190	QC	20 pcs		1/19/18	0.00	0.00	QC5		<i>38</i>
200	Packaging	20 pcs		1/19/18	0.00	0.00	Packaging3		<i>9-89</i>
210	QC21-SA	20 Ea		1/19/18	0.00	0.00	QC21		<i>18/02/01</i>

Part Op 100 - 1-Cut as per Dwg D2348

Descriptions: 150 - Issue P/O: *035542* Black Anodize per Dwg D2348 Ensure Certificate of Conformity is attached

160 - Ensure certificate of conformity is attached

170 - INSPECT CERTS

180 - Install Insert as per Dwg D2348

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.063	0	214	0	0
180-Small Fab	D3996-FE-832-EF	80	74	0	0

5000547 6x
F1601667 14x *5019425 60x*

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wear Plate	0.250Inches ± 0.010	0.260 0.240		
2	Wear Plate	0.648Inches ± 0.010	0.658 0.638		
3	Wear Plate	0.795Inches ± 0.005	0.800 0.790		
4	Wear Plate	2.046Inches ± 0.010	2.056 2.036		
5	Wear Plate	1.295Inches ± 0.010	1.305 1.285		
6	Wear Plate	0.656Inches	0.661	Diameter	

WORK ORDER NON-CONFORMANCE / UPDATE

DART
AEROSPACE

QA Closed:

Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS ☐ Engineering ☐ Quality ☐ Other	
Date :		Step #:			
Description Work Order Deviation The Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE S031927 Wearplate (Key Way) PART NO: D2348 Original Serial #: S031927 Revision: Operation: Change No: Start up Operation 01/13/18 Job No: 170304					

			+ 0.005	0.656	
			- 0.000		
7	Wear Plate	0.290Inches	+ 0.003 - 0.000	0.293 0.290	Diameter
8	Wear Plate	0.250Inches	± 0.010	0.260 0.240	Diameter
9	Wear Plate	0.250Inches	± 0.010	0.260 0.240	
10	Wear Plate	0.648Inches	± 0.010	0.658 0.638	
11	Wear Plate	1.546Inches	± 0.005	1.551 1.541	

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WORK ORDER NON-CONFORMANCE / UPDATE

AEROSPACE

QA Closed:

Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



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Inventory

Operation Number	Operation	Serial Number	Job	Master Unit Number	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No	Inventory Type
Part Number: D2348 Revision: Wearplate (Key Way)																
210	QC21-SA	S031927	170304		20 Ea	0	S031927	ST006		Stock	1/13/2018	Issue Container				False
Operation Totals:		1			20	0										
Part Totals:		1			20	0										
Part Number: D3996-FE-832-EF Revision: Self-Clinching Fastener																
140	QC21-SA	F162765	170304		1 Ea	0	162765	GA		Allocated	10/10/2017	*				False
Operation Totals:		1			1	0										
Part Totals:		1			1	0										
Part Number: FE-832-EF Revision: Pem Insert D3996-FE-832-EF																
100	Receive Ea	S037099	170304		40 Ea	0		GA		Stock	1/30/2018	*				False
		S037109	170304		14 Ea	0		GA		Stock	1/30/2018	Issue Container				False
		S037214	170304		6 Ea	0		Small Fab		Allocated	1/31/2018	*				False
Operation Totals:		3			60	0										
Part Totals:		3			60	0										
Totals:		5			81	0										

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